



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D119-796-101
Job Sheet 190324



Part No: D119-796-101

Job Qty: 1 pcs

Part Name: Fwd Crosstube Installation With Step



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/19

Job Tracking No:

Due Date: 2/28/19

Created By: Marie Lajeunesse

Type: Stock

Description: BROUSSARD

Note: DWG DSI9730 REV B, IIN-D119-796 REV F IPP REV:A NEW ISSUE 14-09-05 DD VERF:JLM IPP REV:B 14.10.22 AS PER PA1 DD VERF:JLM IPP REV:C 14.11.19 AS PER IIN REV.B DD VERF:JLM IPP REV:D 15.02.12 PER REV C JLM VERIFIED BY:DD IPP REV:E 15.05.13 PER REV D JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
95	Crosstubes - 1	1 pcs	2/28/19	2/28/19	0.00	10.00	Crosstubes - 1	
							Crosstubes - 2	
							Crosstubes - 3	
							Crosstubes - 4	
110	Packaging 1-1 - Pick Kit - B4B	1 pcs	2/28/19	2/28/19	0.00	0.00	Packaging 1 - 1 - B4B	
							Packaging 1 - 2 - B4B	
							Packaging 1 - 3 - B4B	
							Packaging 1 - 4 - B4B	
							Packaging 1 - 5 - B4B	
							Packaging 1 - 6 - B4B	
							Packaging 1 - 7 - B4B	
							Packaging 1 - 8 - B4B	
							Packaging 1 - 9 - B4B	
							Packaging 1 - 10 - B4B	
							Packaging 1 - 11 - B4B	
							Packaging 1 - 12 - B4B	
							Packaging 1 - 13 - B4B	
							Packaging 1 - 14 - B4B	
							Packaging 1 - 15 - B4B	
							Packaging 1 - 16 - B4B	
							Packaging 1 - 17 - B4B	
							Packaging 1 - 18 - B4B	
							Packaging 1 - 19 - B4B	
							Packaging 1 - 20 - B4B	
							Packaging 1 - 21 - B4B	
							Packaging 1 - 22 - B4B	
							Packaging 1 - 23 - B4B	
							Packaging 1 - 24 - B4B	
							Packaging 1 - 25 - B4B	
							Packaging 1 - 26 - B4B	

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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S202320

Part: D119-796-101

Job No: 190324

Serial No/Batch: S202320

Revision: G

Inspector:

Exp Date:

Instructions: TC STC SH14-45 - Issue 1, EASA/STC SR03504NY 15/01/28, EASA

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120 QC 4	1 pcs	2/28/19	0.00	0.00	Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					QC 4 - 26	
120 QC 4	1 pcs	2/28/19	0.00	0.00	QC 4 - 28	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
130 Packaging 3-1 - Stock - B4B	1 pcs	2/28/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
135 DC - 1 - B4B	1 pcs	2/28/19	0.00	0.00	DC - 1 - B4B	
					DC - 2 - B4B	
140 QC 21 - FG	1 pcs	2/28/19	0.00	0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op 120 - (QC4- 100% Inspect kits for completeness)
 Descriptions: 130 - (Identify as per dwg & Stock Location: _____), Identify and pack for shipping as per PPP D119-796-101

135 - Photocopy bluefile & type labels per PPP D119-796-101 CHG004
 140 - (QC21- Final Inspection - Work Order Release)

O 11/85

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN5C32A	Bolt	4 Ea (4 ea)	95-Crosstubes - 1	5161088
ANEC7A	Bolt	12 Ea (12 ea)	95-Crosstubes - 1	5041128
D119-796-151	Fwd Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	95-Crosstubes - 1	5196581
D3672-7	Washer, Phenolic	8 pcs (8 ea)	95-Crosstubes - 1	5131558
MS21043-5	Nut	4 Ea (4 ea)	95-Crosstubes - 1	5156842
MS21250-05048	Bolt (Use Ms21250-05-048)	4 Ea (4 ea)	95-Crosstubes - 1	5167331
NAS1149C0532R	Washer	8 Ea (8 ea)	95-Crosstubes - 1	5161942
NAS1149C0563R	Washer	12 Ea (12 ea)	95-Crosstubes - 1	5167660

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
95-Crosstubes - 1	AN5C32A	4	43	0
	AN5C7A	12	142	0
	D119-796-151	1	0	0
	D3672-7	8	973	0
	MS21043-5	4	114	0
	MS21250-05048	4	0	0
	NAS1149C0532R	8	348	0
	NAS1149C0563R	12	120	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



DISPOSITION		DEPARTMENT/PROCESS					
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐		
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐		
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐	Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042) _____			
Description Work Order Deviation		Disposition					
Root Cause		FAULT CATEGORY					
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐			
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐			
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐			
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐			
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐				
Human Factors ☐	Other/Details: _____						

5.0 PARTS LIST

5.1 STANDARD GEAR CROSSTUBES

Item	-101	-201	-103	-203	-141	-241	-151	-251	Part Number	Description
	X								D119-796-101	FWD CROSSTUBE INSTALLATION WITH PEG STEPS
		X							D119-796-201	AFT CROSSTUBE INSTALLATION WITH PEG STEPS
			X						D119-796-103	FWD CROSSTUBE INSTALLATION W/O PEG STEPS
				X					D119-796-203	AFT CROSSTUBE INSTALLATION W/O PEG STEPS
			1		X		1		D119-796-141	CROSSTUBE INSTALLATION, STANDARD FWD, W/O PEG STEPS
				1		X		1	D119-796-241	CROSSTUBE INSTALLATION, STANDARD AFT, W/O PEG STEPS
	X						X		D119-796-151	CROSSTUBE INSTALLATION, STANDARD FWD, WITH PEG STEPS
		1						X	D119-796-251	CROSSTUBE INSTALLATION, STANDARD AFT, WITH PEG STEPS
1					4	4			D2873-043	RADIUS BLOCK
2	X	8	8	8					D5672-7	WASHER
3						1			D5122-1	CENTER SUPPORT
4						6			D5123-1	CLAMP CUSHION
5					4		4	4	D5123-3	CLAMP CUSHION
6						2			D5123-5	CLAMP CUSHION
7					2				D5124-1	FWD SUPPORT
8						1			D5134-041	DAMPER SUPPORT ASSY, LH
9						1			D5134-042	DAMPER SUPPORT ASSY, RH
10						1			D5136-1	CONTACT PAD, LH
11						1			D5136-2	CONTACT PAD, RH
12							2		D5149-041	FWD STEP ASSY
13								2	D5149-043	AFT STEP ASSY
14					2				D5152-041	FWD POST MOUNT ASSY
15						2			D5152-043	AFT POST MOUNT ASSY
16					2				D5305-1	SHIM
17						2			D5515-1	GROUNDING CLAMP
18						2			AN174-3A	BOLT
19	X	12	12	12					AN307A	BOLT
20	X	4	4	4					AN307A	BOLT
21						16			CR3212-4-07	RIVET
22					16				CR3212-4-08	RIVET
23							4		MS21920-22	CLAMP
24					4				MS21920-24	CLAMP
25						6		4	MS21920-25	CLAMP
26		2		2		2			MS21920-28	CLAMP
27	X	4	4	4					MS21250-08048	BOLT
28						2			MS21042-3	NUT
29						2			MS21042-4	NUT
30	X	4	4	4					MS21042-5	NUT
31						2			MS27039-1-08	SCREW
32						4			NAS1149D0332J	WASHER
33						4			NAS1149D0432J	WASHER
34	X	8	8	8					NAS1149C0532R	WASHER
35	X	12	12	12					NAS1149C0533R	WASHER
100		1		1					DP460	SCOTCH WELD ADHESIVE (37mL)

1

Part Number: D119-796-101

Description: FWD CROSSTUBE INSTALLATION WITH PEG STEPS

[illegible]